

Work Order ID 69717

Tuesday, May 17, 2011 3:48:22 PM



Page 1

Item ID: DSK081

Accept



Setup Start



Revision ID:

Stop



Item Name: D2940-1 TURNING DETAIL

Start Date: 5/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-05-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK081	Rev A								

100



Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

Memo

Turn blank as per Folio FA079

0.00

0.00

2R 11-5-30

4

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

2R 11-5-30

4

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

2R 11-5-30

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69717

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

2P 11.5.31

4

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: CNC

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13
MPC
11-07-13

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Picklist Print

Tuesday, May 17, 2011 3:48:34 PM

Page 1

Work Order ID: 69717



Parent Item: DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 5/17/2011

Required Date: 5/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-007

Manufactured

No

Each

4.0000

10



20 11.5.30

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

4

53752 ✓

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

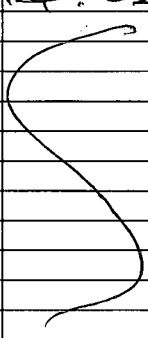
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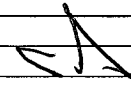
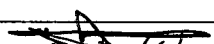
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

DART AEROSPACE LTD		Work Order:	09717
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	
B	4.946	4.966		4.956	4.956	4.956	4.956	
C	0.718	0.738		.726	.726	.726	.726	
D	0.090	0.110		.103	.103	.103	.103	
E	3.564	3.584		3.575	3.575	3.575	3.575	
F	0.022	0.042		.032	.032	.032	.032	
G	3.444	3.464		3.455	3.455	3.455	3.455	
H	0.112	0.132		.122	.122	.122	.122	
I	2.170	2.190		2.178	2.178	2.178	2.178	
J	4.451	4.471		4.463	4.463	4.463	4.463	
K	0.413	0.433		.425	.425	.425	.425	
L	0.913	0.933		.921	.921	.921	.921	
M								
N								
O								
P								

Measured by: 	Date: 11-5-31
Audited by: H-S-31 	Date: 11/5/31
Prototype Approval: 	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

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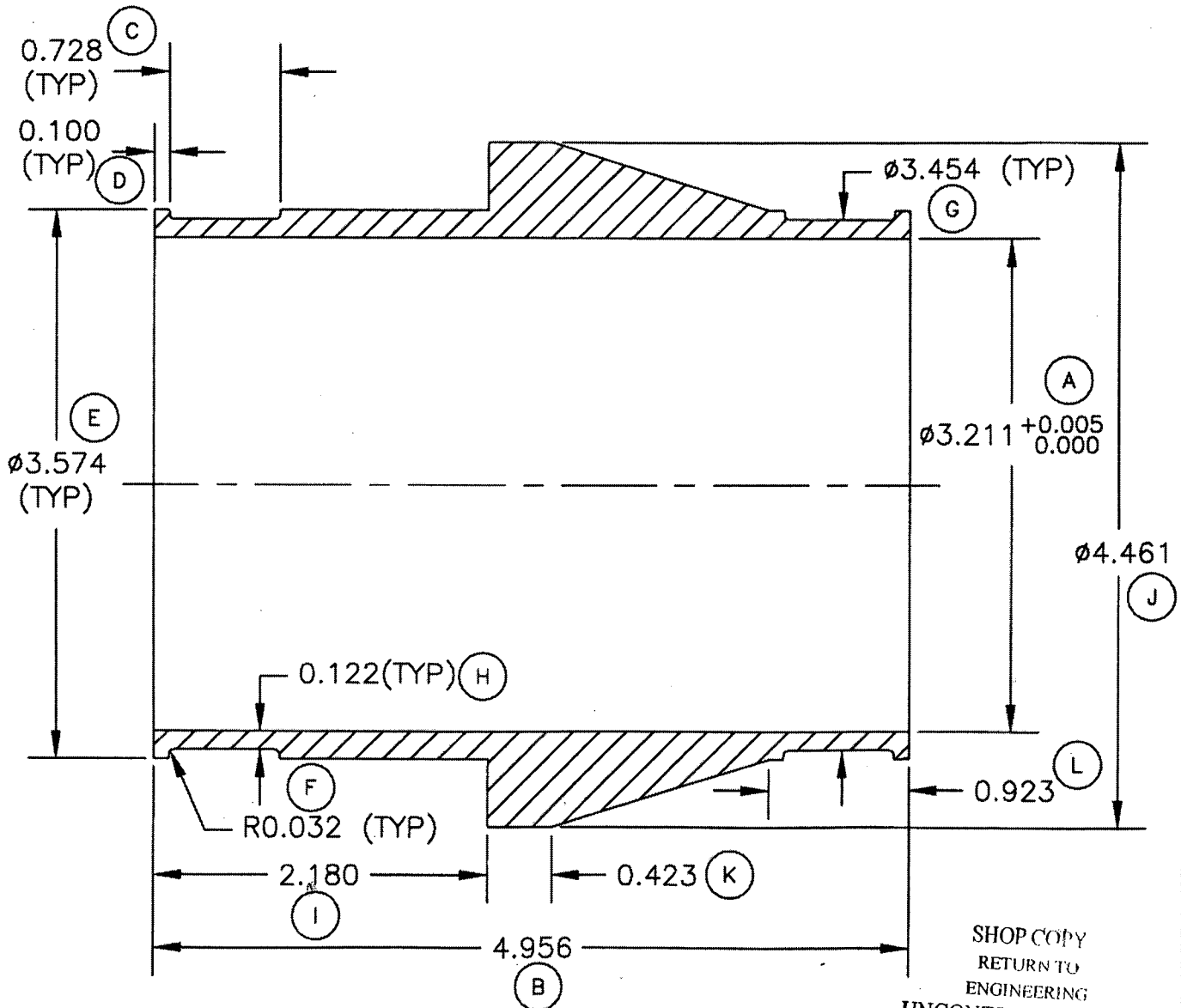
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DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03-07-01 [Signature]D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69717

M/105-17

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